

Work Order ID 77857

77857

Page 1

December-22-11 8:51:54 AM

Item ID: D044-717-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Cold Weather Baffle

Stop *NS2*

Start Date: 22/12/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/12/22 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D044-717-011CHG001

8/2/02/17

for M.L.J 12-2-17
(5)

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

SP 12-02-16.

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

8/2/02/17

(XS)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77857***77857***

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Item ID: D044-717-011

Accept

N900040100Setup Start ***NS1***

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Stop ***NS2***

Item Name: Cold Weather Baffle

Start Date: 22/12/2011 Start Qty: 4.00

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Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D044-717-011								
	Location: _____								
	PPP Rev: <u>B F6010</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

R120217
(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 77857

77857

Parent Item: D044-717-011

D044-717-011

Parent Item Name: Cold Weather Baffle

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:B Removed Manufacturing 05-12-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3276-041

Manufactured

No

110

Each

0.0000

1

**

D3276-041

Baffle Assembly LH

D3276-042

Manufactured

No

110

Each

2.0000

1

**

D3276-042

Baffle Assembly RH

Location

Loc Qty

Loc Code

st175

2

75134

2

D3383-1

Manufactured

No

110

Each

32.0000

1

**

D3383-1

Placard

Location

Loc Qty

Loc Code

ST051

32

59381

2

75135

10

76967

20

AN526C1032R7

Purchased

No

110

Each

160.0000

8

**

AN526C1032R7

Screw

Location

Loc Qty

Loc Code

ST348

160

116304

8

119436

2

119449

150

45
B76167 5x SP. 1

45

B76168 3x SP. 1

2x

45

SP

5x

3240

SP 12-02-16.

40x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

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December-22-11 8:51:58 AM

Work Order ID: 77857

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Parent Item: D044-717-011

D044-717-011

Parent Item Name: Cold Weather Baffle

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 4.00

Required Qty: 4.00

MS20426AD3-4

Purchased

No

110

Each

4,464.000

16

**

MS20426AD3-4

RIVET

Location

Loc Qty

Loc Code

ST316

4464

104374

1100

110398

3364

MS21059L3

Purchased

No

110

Each

143.0000

8

**

MS21059L3

Nut Plate

Location

Loc Qty

Loc Code

ST301

143

118614

43

119546

100

64 80
SP

80x
32 40x

SP 12-02-16

40x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

REFERENCE ONLY

2.0 GENERAL NOTES

COMPATIBILITY

Compatibility of this installation with the aircraft is the **responsibility of the installer**. Ensure that this installation does not conflict with a previous modification.

CONTINUING AIRWORTHINESS

These installations should be maintained in accordance with the Instructions for Continued Airworthiness ICA-D044-717. Refer to the Aircraft Maintenance Manual for standard shop practices not referred to in these Installation Instructions.

3.0 INSTALLATION PROCEDURE

The Dart D044-717-011 Cold Weather Baffle Kit should be installed as follows:

- 3.1 Temporarily locate the D3276-041 Baffle Assembly on the LH inlet as shown in Figure 1. Transfer drill the 4 holes to the aircraft and enlarge to $\varnothing 0.203$ " (5.20mm). Ensure minimum edge distance of 0.300" from center of hole to edge of opening.
- 3.2 Drill $\varnothing 0.098$ " holes for MS20426AD3-4 rivets that will be used to install the MS21059L3 nutplates. C'sink $\varnothing 0.179$ "x100° (4.55mm x100°).
- 3.3 Deburr all drilled/c'sink holes and touch-up with primer per the Aircraft Maintenance Manual.
- 3.4 Install MS21059L3 nutplates on a/c holes using MS20426AD3-4 rivets. Install the D3276-041 Baffle Assembly using AN526C1032-7 screws. Torque screws 15-25 in-lb (2-3 Nm)
- 3.5 Repeat installation for RH side using D3276-042 Baffle Assembly.
- 3.6 Install D3383-1 Placard in full view of the pilot.

4.0 WEIGHT AND BALANCE

The following is the net weight increase associated with the installation.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-717-011	0.86 lb	0	0	160 in	138 in-lb
Cold Weather Baffle Kit	0.39 kg	0	0	4.06 m	1.6 m-kG

5.0 PARTS LIST

Qty -011	Part Number	Description
X	D044-717-011	COLD WEATHER BAFFLE KIT
1	D3276-041	BAFFLE ASSEMBLY, LH
1	D3276-042	BAFFLE ASSEMBLY, RH
1	D3383-1	PLACARD
8	AN526C1032-7	SCREW
16	MS20426AD3-4	RIVET
8	MS21059L3	NUTPLATE

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Revision: **B**

Date: 05.01.25